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D4776-1

Job Sheet 184281



Part No: D4776-1

Job Qty: 10 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Machining-3		
100	Doosan	10 pcs	10/19/18	10/19/18	0.54	5.32	Doosan		
105	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC2 Machining-3		
111	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC8 Machining-3		
112	HandFinish	10 pcs	10/19/18	10/19/18	0.00	0.29	HandFinish1		
113	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC7-4		
115	Powdercoat	10 pcs	10/19/18	10/19/18	0.00	0.12	Powdercoat1		
116	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC3		
130	Packaging	10 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea	10/19/18	10/19/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M 138 951

START 8:00

OUT TO 320° FINISH: 8:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	2.9000 ft (.29 ea)	90-Start up Operation	5123406

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	3	22	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850	0.8805	
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428	0.438	
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350	0.379	
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615	0.6245	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720	1.7525	
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470	3.501	
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	45°
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000	.028	
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	Radius	R 1/8
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter	Ø .198
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter	Ø .262
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	Radius	R .408
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100	1.1305	
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178	.188	
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160	.191	
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470	.501	
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740	.749	
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter	.4005 * 1" TAPER
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	Radius	R 1/8
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750	.7535	
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130	.156	
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	45°

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

FAULT CATEGORY	
☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Misabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence

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AEROSPACE

Container No: S125847



Part: D4776-1

Job No: 184281

Serial No/Batch: S125847

Revision:

Inspector:

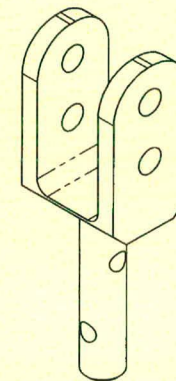
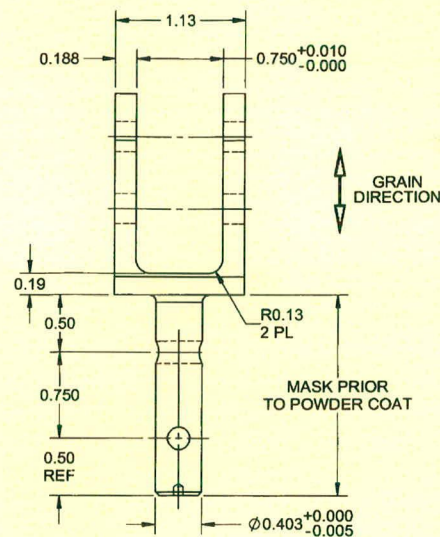
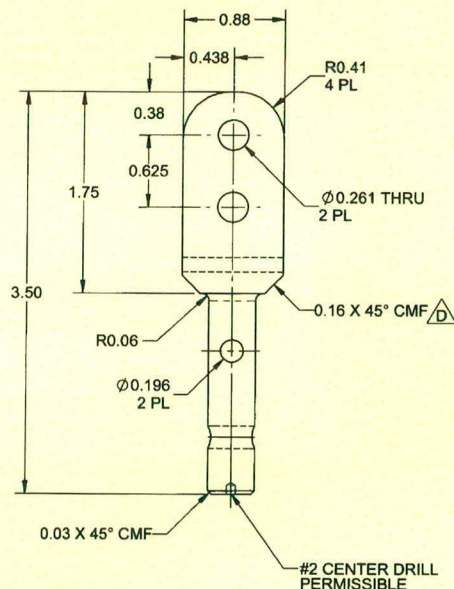
Exp Date:

Instructions: Various STC's

Date: 11/08/18

H/

Insurance approved QA/NCRWO Rev I



UNDER REVIEW
URF 18-803 SAD
18.09.12

RELEASED
2014-07-30

D4776-1 BASKET STRUT CLEVIS

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

D	SHT 1, C6 CHAMFER ADDED. SEE PAR 14-353. SHT 2 ZONE B2 1.813 DIM ADDED FOR CLARITY. ZONE B3 0.53 DIM CORRECTED TO 0.55 DUE TO DESIGN ERROR SEE PAR 14-328.	AJS	14.07.14
C	SHT 2, C7, 1.13 DIM WAS 0.88, C8 0.688 WAS 0.438, ADDED TOP VIEW WITH CHAMFERS. REASON: INTERFERENCE WITH OEM SADDLES.	AJS	13.10.31
B	MULTIPLE DIMENSIONS UPDATED ON -1 FOR INSTALLATION OF 1/4" FASTENERS. INDEX OF HOLES ON THE STEM OF -1 ROTATED 90°. FINISH ADDED TO -1 TOLERANCE ON CLEVIS FOR -1 & -3 TIGHTENED. ADDED -5. REASON: EASE OF INSTALLATION. C3-2 DEPTH DIM ADDED.	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4776	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET STRUT MACHINED PARTS	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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